

Work Order ID 57985

April 21, 2010 10:07:09 AM



Page 1

Item ID: D3565-1

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 21/04/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date: 10-4-21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3565

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3565
Deburr if necessary

☐ Dwg Rev:

C

☐ Prog Rev:

C

☐ 2-

B 10-4-27

364 063



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 10-4-27

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/2010

44

P10 ->

WIO: 57985		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/4/27	#120	Took Qty of For QC inspection template	S	10/4/27	4		S 10/04/27

Part No: D3565-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Large Fab	Large Fab	0.00							
Large Fab	Memo	0.00							
	1-Weld D3009-3 cups as per dwg D3565 2-Weld hard facing as per Dwg D3565 using DT8991 jig A/R 2059B Hard Coat rod Batch: <u>M174 373</u>								
140 QC	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
Quality Control	Memo	0.00							
150 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							

EL 10-4-28 (X11)

(X11) 10.04.28

Siobhán

(X11)

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

START TIME:

7:00am

FINISH TIME:

OVEN TEMPERATURE:

320°F

2) 10/04/30

11

Ø

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

11

10-4-30

180



Packaging

Packaging

Identify as per dwg & Stock Location

497A

0.00

Memo

0.00

10-5-4

110

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/04 *AG**U 10.05.04*

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Picklist Print

April 21, 2010 10:07:13 AM

Page 1

Work Order ID: 57985

Parent Item: D3565-1

Parent Item Name: Wearplate

Comments: IPP Rev :A New Issue 07-01-16 JLM
IPP rev B revB dwg 07.04.18 ec
IPP Rev:C rev.c as per dwg 08-01-14 DD verified by:
IPP Rev: D QC5 added to step 8 08.12.22 KJ Verified by:

Start Date: 21/04/2010

Required Date: 28/04/2010

Start Qty: 8.00

Required Qty: 8.00

D3009-3 Manufactured No 100 Each 398.0000 24.0000



Cup



12 10-4-28

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

398

42377

398

M304S16GA

Purchased

No

130

sf

0.0000

1.1368



33

1.8

18 10-4-27

304/316 Sheet .063

12

304.003 114467

114467

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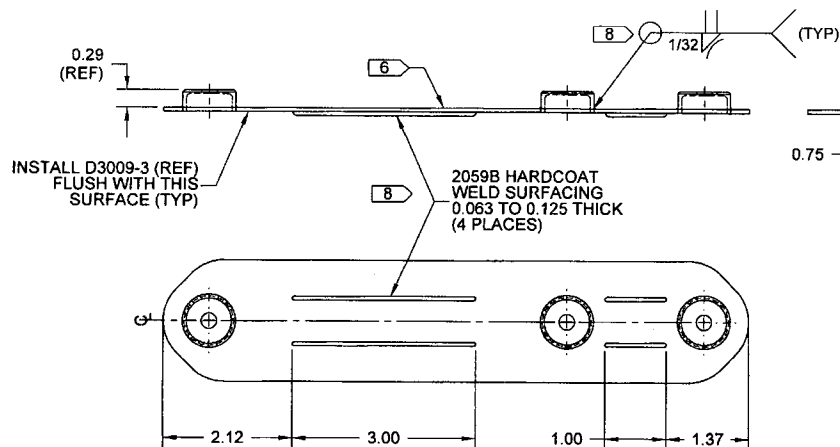
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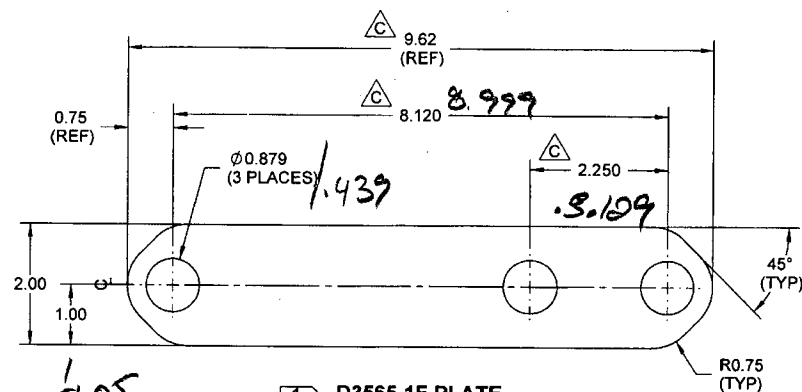
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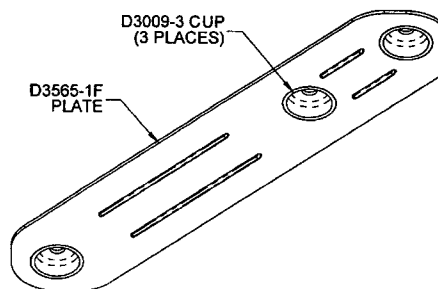
NOTE: Date & initial all entries



D3565-1 R44 WEARPLATE



D3565-1F PLATE



D3565-1 PARTS LIST

QTY -1	P/N	DESCRIPTION
X	D3565-1	R44 WEARPLATE
1	D3565-1F	PLATE
3	D3009-3	CUP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK) PER MIL-S-5059 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S16GA)
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3565-1" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.38 lbs
- 8) WELD PER DART QSI 004
- 9) PART IS SYMMETRIC ABOUT C

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57985

REV.	DESCRIPTION	BY	DATE
C	WEARPLATE NOW WELDED (C7); 8.120 WAS 8.220, 2.250 WAS 2.300 (D2); ADDED PARTS LIST (B7); UPDATED NOTES (A7)	MB	07.12.14
B	8.220 WAS 8.120; 2.300 WAS 2.250; ADD HOLE DIMS AFTER CUP FORMING	CB	07.03.12
A	NEW ISSUE	CB	07.01.09
DESIGN	DR	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3565 TITLE R44 WEARPLATE REV. C SHEET 1 OF 1 SCALE 1:2 COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	JP		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP		
DATE	07.12.14		

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